

ABSTRACT

A press fit fastener (1) includes a shank (2), a head (3) and a press fit portion (4) being located at the shank (2). The head (3) is located at the first end of the shank (2). The press fit portion (4) includes a multiple helical profile (5). The helical profile (5) has a beginning portion (6) and an inclination portion (8). The outer diameter of the inclination portion (8) is designed to increase in a direction towards the head (3) to reach a maximum outer diameter. The maximum outer diameter of the inclination portion (8) is spaced apart from the head (3). The method of producing the press fit fastener (1) includes the steps of cold forming a press fit portion (4) at the shank (2) of the fastener (1) to produce a cylindrical helical profile (5) including a plurality of pitches, and calibrating the helical profile (5) without producing chips to produce an inclination portion (8) in which the outer diameter of the press fit portion (4) in a direction towards the head (3) increases to reach the maximum outer diameter. The maximum outer diameter of the inclination portion (8) being spaced apart from the head (3).